

Date: Friday, 03/04/2009 1:00:31 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2891-1
Job Number : 46923	
Estimate Number : 13232	
P.O. Number :	Part Number : DSK076
This Issue : 03/04/2009 S.O. No. :	Drawing Number : DSK076 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 44410	Material :
Written By :	Due Date : 10/04/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JHD 09-04-03</u>	
Comment : est rev A. 08.03.13 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6104003	Round Billet, 17-4
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s),

Billet

Batch: B 45036

MF 09/04/05

2.0	DOOSAN LATHE	DOOSAN LATHE
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**Comment:** DOOSAN LATHE

Turn blank for as per Folio FA046

MF 09/04/05

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

MF 09/04/05

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

MF 09/04/05

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: CNC

MF 09/04/05

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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**Comment:** FINAL INSPECTION/W/O RELEASE

09/04/06

Job Completion



MF 09-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

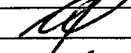

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order: 46923
Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.279	2.279	2.279	2.279	2.279
B	3.702	3.722		3.714	3.714	3.714	3.714	3.714
C	2.564	2.584		2.575	2.575	2.575	2.575	2.575
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.464	2.484		2.474	2.474	2.474	2.474	2.474
G	2.029	2.049		2.039	2.039	2.039	2.039	2.039
H	2.964	2.984		2.974	2.974	2.974	2.974	2.974
I	0.913	0.933		.923	.923	.923	.923	.923
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110		.100	.100	.100	.100	.100
L								
M								
N								
O								
P								

Measured by: 	Date: 07/04/05
Audited by: 	Date: 09/04/05
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

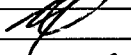

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order: 46923
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L								
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O								
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Measured by: 	Date: 09/04/05
Audited by: 	Date: 09/04/05
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

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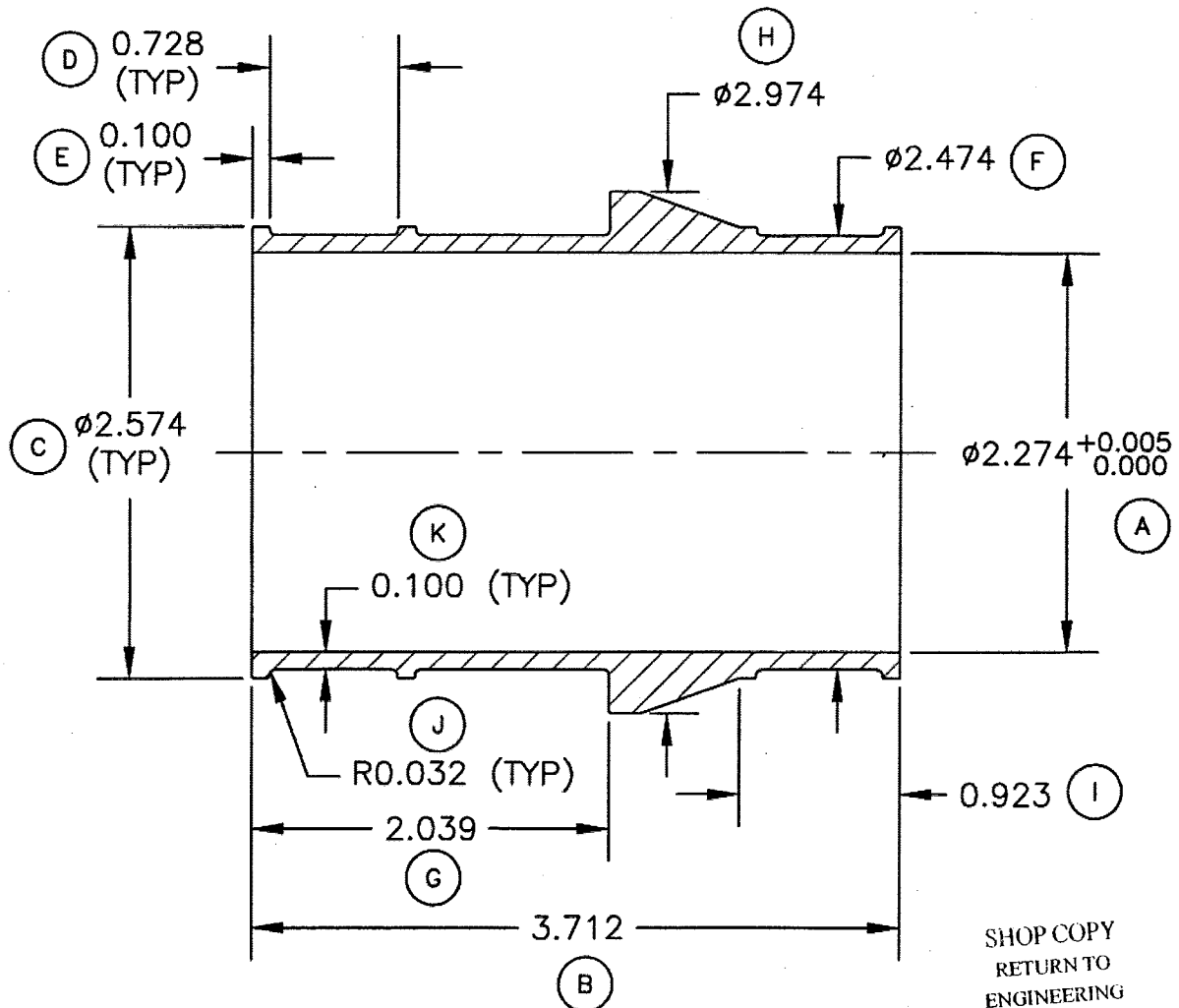
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NOTE: Date & initial all entries

DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CH	APPROVED CH	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 CH

D2891-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46923

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